

Work Order ID 125733

125733

Page 1

Wednesday, October 22, 2014 12:33:35 PM

Item ID: D350-616-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Deck Plate

Start Date: 10/09/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-10-22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-616

G

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and create labels per PPP D350-616-015
CHG004

0.00

DAS
46
9-89

JAN 21 2015

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
46
9-89

JAN 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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125733

Page 2

Item ID: D350-616-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Deck Plate

Start Date: 10/09/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
06
9-09

130

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-616-015

Location: PG 628

PPP Rev: _____

JAN 21 2015

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MCJ 15-01-21

CMF

15-1-29

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 125733

125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 05-12-05 JLM
 IPP Rev:D Add D3494-1 05-12-05 JLM
 IPP rev E added parts per NCR 08-041 08.04.30 EC verified by: DD
 IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G
 13.04.03 PER IIN REV.F DD VERF:JLM IPP REV:H 13.05.21
 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2344 Deck Plate Aft		Manufactured	No			110	Each	24.0000	1	4			
D2344 DAS 46 9-29 Location ST481 114962 Loc Qty 24 24 Loc Code													
D2348 Wearplate (Key Way)		Manufactured	No			110	Each	29.0000	4	16			
D2348 DAS 46 9-29 Location ST006 119381 Loc Qty 29 29 Loc Code													
D2353 Stiffener		Manufactured	No			110	Each	48.0000	1	4			
D2353 DAS 46 9-29 Location ST256 120290 Loc Qty 48 48 Loc Code													

JAN 20 2015

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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 125733

125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

D2364

Manufactured No

110

Each

27.0000

1

4

D2364

Deck Plate Fwd

DAS
46
9-89

**

Location

Loc Qty

Loc Code

ST482

27

107161

1

120134

26

D2365

Manufactured No

110

Each

38.0000

2

8

D2365

Wearplate Pip Pin

DAS
46
9-89

**

Location

Loc Qty

Loc Code

ST006

38

110654

4

115566

19

120093

15

D2369-1

Manufactured No

110

Each

14.0000

1

4

D2369-1

Locator Plate

DAS
46
9-89

**

Location

Loc Qty

Loc Code

ST217

8

116857

2

119412

4

122935

2

ST241A

6

114992

3

115691

3

JAN 20 2015

DQA: _____ Date: _____



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Equip/Tooling									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 125733

125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

D2369-3

Manufactured No

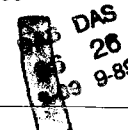
110

Each

12.0000

1 4

**



D2369-3

Locator Plate

DAS
46
9-89

Location

Loc Qty

Loc Code

ST217

12

120585

12

Each

31.0000

**

4X
4



D4778-1

Manufactured No

D4778-1

Stub Cover

DAS
46
9-89

Location

Loc Qty

Loc Code

ST234

31

111604

13

117485

18

Each

15.0000

**

4X
4



D4779-041

Manufactured No

D4779-041

Aft Cover Mounting Bracket Assembly

DAS
46
9-89

Location

Loc Qty

Loc Code

ST121

15

115194

1

116141

4

123540

10

Each

13.0000

**

2X
2X
4



D4780-041

Manufactured No

D4780-041

Fwd Cover Mounting Bracket Assembly

DAS
46
9-89

Location

Loc Qty

Loc Code

ST121

13

122612

1

123436

12

2X B/20 B27

JAN 20 2015

2X

Wednesday, October 22, 2014 12:33:33 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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Page 4

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125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-5

Purchased

No

110

Each

452.0000

25

100

MS20426AD4-5

RIVET

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312

452

6874

70

m125807

382

MS20426AD4-6

Purchased

No

110

Each

2,349.000

25

100

MS20426AD4-6

Rivet

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312

2349

124392

462

M128812

1887

MS20426AD5-7

Purchased

No

110

Each

1,592.000

6

24

MS20426AD5-7

RIVET

DAS
46
9-89

Location

Loc Qty

Loc Code

ST312

1592

101340

1592

MS20426AD5-8

Purchased

No

110

Each

548.0000

6

24

MS20426AD5-8

RIVET

DAS
46
9-89

Location

Loc Qty

Loc Code

ST311

548

4533

548

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

JAN 20 2015

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 125733

125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

MS20601-AD4W2

Purchased

No

110

Each

95.0000

15 60

**

M130922

DAS
26
9-89

MS20601-AD4W2

Rivet

DAS

46

9-89

Location

Loc Qty

Loc Code

ST308

95

121255

32

m126975

38

m128300

2

m129472

23

MS20601-AD4W3

Purchased

No

110

Each

412.0000

30 120

**

MS20601-AD4W3

Rivet

DAS

46

9-89

Location

Loc Qty

Loc Code

ST308

412

114538

320

124331

92

22x M124331

DOX 98X

DAS
26
9-89

MS21042L3

Purchased

No

110

Each

1,488.000

6 24

**

M131264

DAS
26
9-89

MS21042L3

Nut

DAS

46

9-89

Location

Loc Qty

Loc Code

ST305

1488

123900

913

M127410

11

M127831

41

M128401

42

M128754

481

JAN 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 6

Work Order ID: 125733

125733

Parent Item: D350-616-015

D350-616-015

Parent Item Name: Deck Plate

Start Date: 10/09/14

Required Date: 10/21/14

Start Qty: 4.00

Required Qty: 4.00

MS24693-C273

Purchased

No

110

Each

115.0000

6

24

MS24693-C273

SCREW

DAS
46
9-89

Location

Loc Qty

Loc Code

ST291

115

m127305

2

m128401

113

110

Each

262.0000

22

88

MS24693-C48

Purchased

No

MS24693-C48

SCREW

DAS
46
9-89

Location

Loc Qty

Loc Code

ST291

262

m128429

12

m128818

250

Each

357.0000

32

MS35207-263

Purchased

No

MS35207-263

Screw

DAS
46
9-89

Location

Loc Qty

Loc Code

ST282

357

104746

357

110

Each

1,843.000

14

56

NAS1149D0363J

Purchased

No

NAS1149D0363J

Washer

DAS
46
9-89

Location

Loc Qty

Loc Code

GA

7

124392

7

ST276

805

m123441

5

m130358

800

ST510a

1031

m128429

1031

JAN 20 2015

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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9-89



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 13.04.01
CERT. NO.: SH96-10
ISSUE NO.: 3